

Quase. Ship 24/01

Work Order ID 65396



Page 1

January 14, 2011 12:58:53 PM

Item ID: D350-591-311

Accept



Setup Start



Revision ID:

Item Name: Heli-Access-Step, Long LH

Stop



Start Date: 1/14/11 Start Qty: 1.00



Cust Item ID:

Required Date: 1/21/11 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

W Sula 1/12/11

for CL 11/01/21

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod

M108436
M115928

3-Grind End Plate flush

11-01-19

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 65396

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Required Date: 1/21/11 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

1 0 BE 11/01/19

130

QC5- Inspect part completeness to step on W/O

0.00



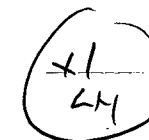
QC

Memo

0.00

Quality Control

Sublot 9



140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1 BE 11-01-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item Name: Heli-Access-Step, Long LH

Start Date: 1/14/11 Start Qty: 1.00



Cust Item ID:

Required Date: 1/21/11 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

*el 11/01/11**1 0*

Quality Control

180

Large Fab

0.00



Large Fab

Memo

0.00

*11-01-19**1 0*

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/R ☐ Aluminum Rod *M108436*

6-Grind End Plate flush

7-Install last rivet as per Dwg.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID 65396

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Setup Start

Revision ID:

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Item Name: Heli-Access-Step, Long LH

Start Date: 1/14/11 Start Qty: 1.00

Cust Item ID:

Required Date: 1/21/11 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

1 0 BE 11/01/20

200

QC5- Inspect part completeness to step on W/O

0.00



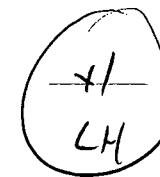
QC

Memo

0.00

Quality Control

8 ul 01/20



210

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1 - BR 11-01-20.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D350-591-311

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Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 1/14/11 Start Qty: 1.00



Cust Item ID:

Required Date: 1/21/11 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



M115951

1 BR 11-a-20

Powdercoat

Memo

0.00

Powder Coating

START TIME: 1:45
OVEN TEMPERATURE: 300°
FINISH TIME: 2:15

230

Wing Walk as per dwg QSI005 4.4 Batch M115790

0.00



Memo

0.00

HandFinish

Hand Finishing

1 8

240

QC3- Inspect Part Finish

0.00



Memo

0.00

QC

Quality Control

1 1/1/29-1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID 65396

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Item ID: D350-591-311

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Setup Start

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Stop

Item Name: Heli-Access-Step, Long LH

Start Date: 1/14/11 Start Qty: 1.00

Cust Item ID:

Required Date: 1/21/11 Req'd Qty: 1.00

Customer:


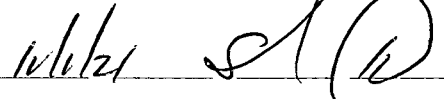



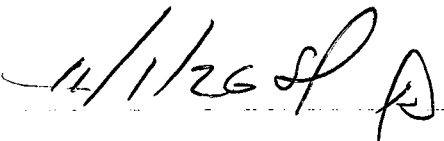
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250  Packaging Packaging	Pick Kit Memo	0.00 0.00							
260  QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00							
270  Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPPD350-591-311 Location: _____	0.00 0.00							

Work Order ID 65396

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Item ID: D350-591-311

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 1/14/11 Start Qty: 1.00



Cust Item ID:

Required Date: 1/21/11 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/26

U 11/01/26

Picklist Print

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Page 1

Work Order ID: 65396

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 1/14/11

Required Date: 1/21/11

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 04.03.22 New issue KJ/RF
IPP Rev:B 07-06-09 Added D3272-1 JLM
IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC
IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3272-1 Step		Manufactured	No			110	Each	8.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				8					
					64912			8					
D3067-1 End Plate		Manufactured	No			110	Each	76.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				76					
					63550			76					
D3219-1 Plate		Manufactured	No			110	Each	73.0000	2	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				73					
					63551			73					
D3066-1 Spacer		Manufactured	No			180	Each	96.0000	2	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				96					
					63549			46					
					65072			50					

11.01.18 865344

11.01.18

11.01.18

11.01.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 65396

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 1/14/11

Required Date: 1/21/11

Start Qty: 1.00

Required Qty: 1.00

MS20600-AD4W4

Purchased

No

180

Each

2,031.000

16

16



Rivets

Location

Loc Qty

Loc Code

ST321

2031

113368

38

114181

11

114718

2

115573

147

115640

31

116022

302

116188

1500

D3065-041

Manufactured

No

180

Each

22.0000

1

1



Step Leg Assembly Hi

Location

Loc Qty

Loc Code

WA

22

63555

22

D3067-1

Manufactured

No

180

Each

76.0000

1

1



End Plate

Location

Loc Qty

Loc Code

WA

76

63550

76

AN3-35A

Purchased

No

250

Each

128.0000

2

2



Bolt

Location

Loc Qty

Loc Code

ST353

128

116191

100

116549

28

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 65396

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 1/14/11

Required Date: 1/21/11

Start Qty: 1.00

Required Qty: 1.00

D3235-1 Manufactured No

250

Each

21.0000

2



Mounting Lug

Location

Loc Qty

Loc Code

ST471

21

61845

1

63547

20

1865073 1/14/11/26

D3278-041 Manufactured No

250

Each

28.0000

1



Support Assembly

Location

Loc Qty

Loc Code

ST471

28

63553

28

11/1/21 SL

AN960JD416 NAS1149D0463J Purchased No

250

Each

30.0000

16



Washer

Location

Loc Qty

Loc Code

ST300

24

113288

24

ST356

6

115622

6

M116304 1/1/21 SL

AN960JD516 NAS1149D0563J Purchased No

250

Each

34.0000

4



Washer

Location

Loc Qty

Loc Code

ST

34

103694

18

107534

12

109287

4

M114742

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Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 65396

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 1/14/11

Required Date: 1/21/11

Start Qty: 1.00

Required Qty: 1.00

AN5-36A

Purchased

No

250

Each

111.0000

2

2



Bolt



1/14/11

Location

Loc Qty

Loc Code

ST341

111

114292

1

116191

60

116549

50

Manufactured

No

250

Each

59.0000

2

2

D2618



Bushing



1/14/11

Location

Loc Qty

Loc Code

ST019

59

65071

59

Manufactured

No

250

Each

14.0000

4

4

D2230-3



Lug



1/14/11

Location

Loc Qty

Loc Code

ST476

14

55452

2

64422

12

Manufactured

No

250

f

248.5810

1.2

1.2

D2856-400



Abraison Strip



1/14/11

Location

Loc Qty

Loc Code

ST403

248.5810421

56626

0.00004211

59920

44.581

63735

204

*** cut (2) at 7.20" (D2856-400-720) ***

measured
8/10/12

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 65396

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 1/14/11

Required Date: 1/21/11

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

250

Each

3,218.000

2

2



Nut



1/14/11

Location

Loc Qty

Loc Code

ST300

3218

114784

9

115835

709

116391

900

116540

800

116549

800

2

AN4-13A

Purchased

No

250

Each

19.0000

8

8



Bolt



1116669 1/14/11

Location

Loc Qty

Loc Code

ST357

19

116191

19

MS21042L5

Purchased

No

250

Each

1,297.000

2

2



Nut



1/14/11

12

Location

Loc Qty

Loc Code

ST139

26

114813

26

ST300

1271

115156

5

115594

500

116104

70

116105

496

116548

200

2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 65396

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 1/14/11

Required Date: 1/21/11

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

250

Each

4,606.000

8



Nut



11/12/11

Location

Loc Qty

Loc Code

ST300

4606

1123143

2

115589

10

115621

94

116188

3500

116548

1000

AN960JD10

NAS1149D0363J

Purchased

No

250

Each

8.0000

4



Washer



11/16/11

11/12/11

Location

Loc Qty

Loc Code

ST

6

107715

6

ST335

2

105792

2

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W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART

DESIGN 90	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED H	DRAWING NO. D3272	REV. E. SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED07.06.04 **H**

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

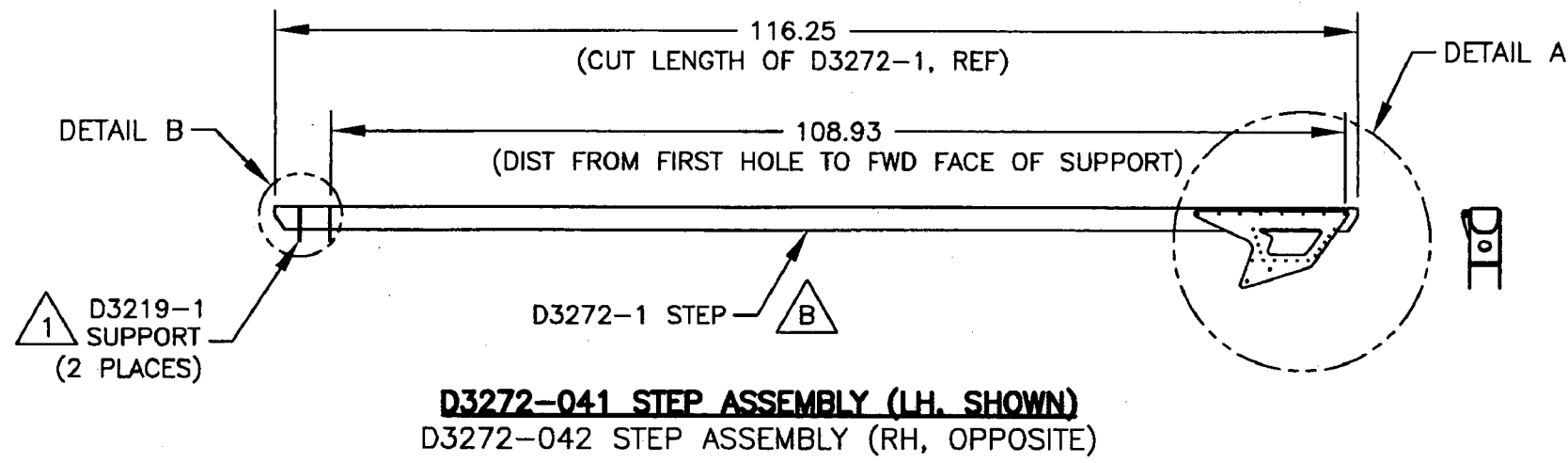
- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

1/10 68396

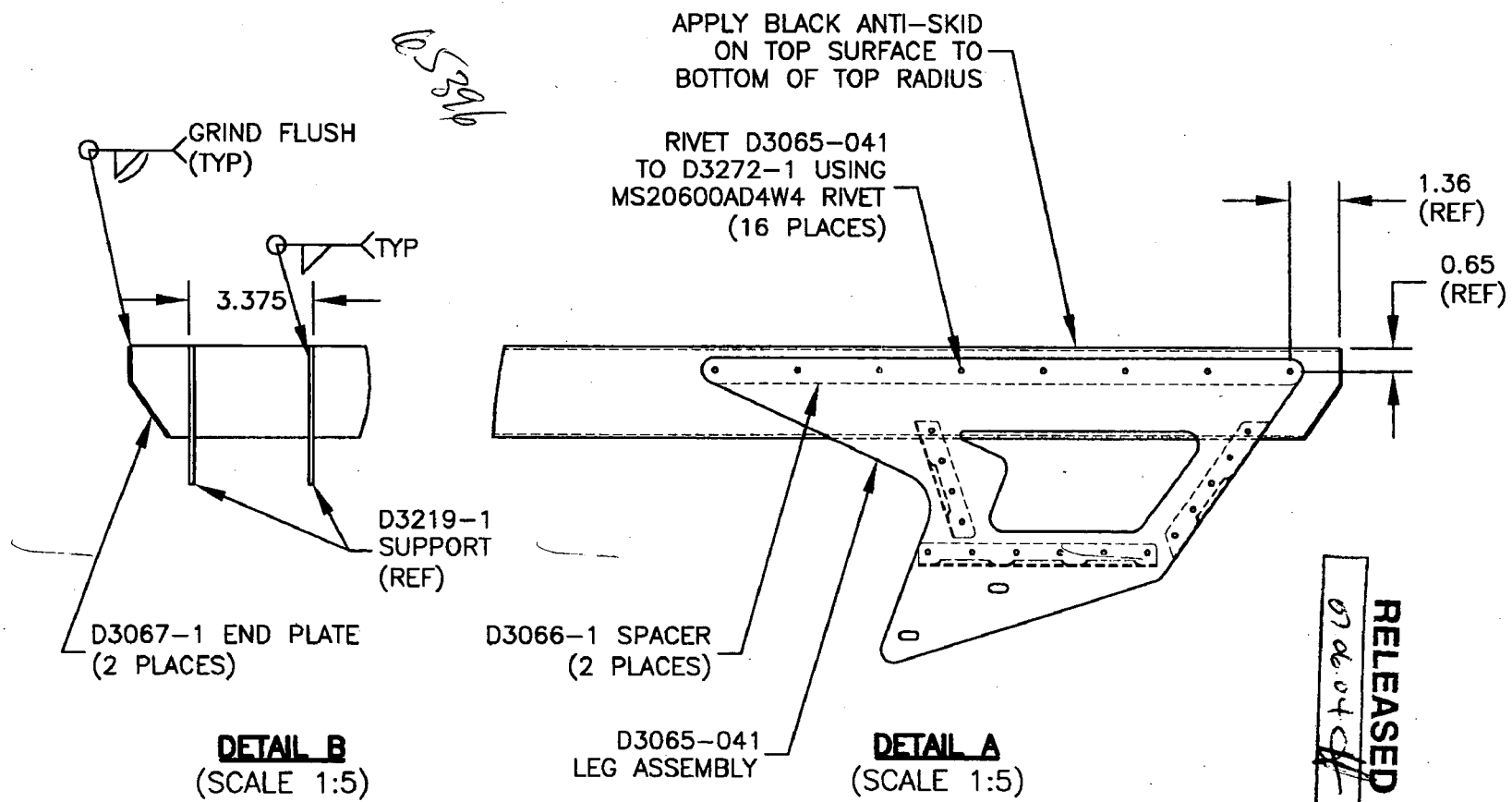


DESIGN	DRAWN BY	DART AEROSPACE LTD
90	JB	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
CE	CH	D3272
DATE	TITLE	REV. E
07.05.18	STEP ASSEMBLY, HI LONG	SHEET 2 OF 2
		SCALE
		1:20

RELEASED
07.06.04 CH



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

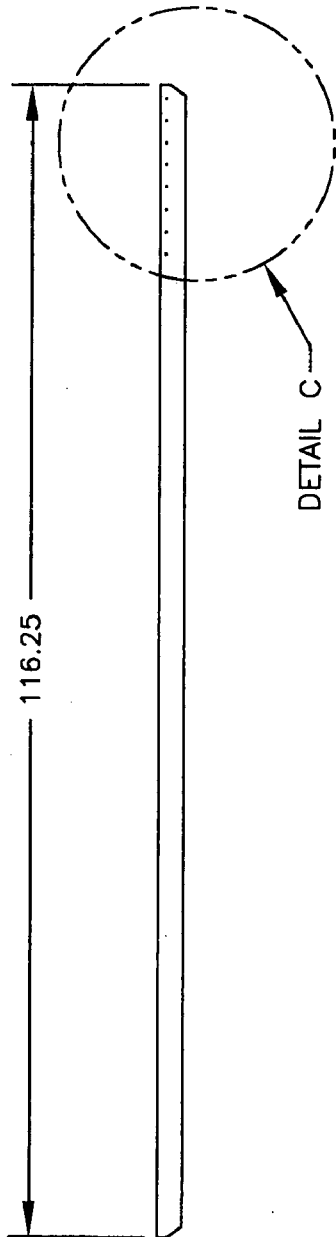




DESIGN <i>9P</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED

07.06.04 *[Signature]*

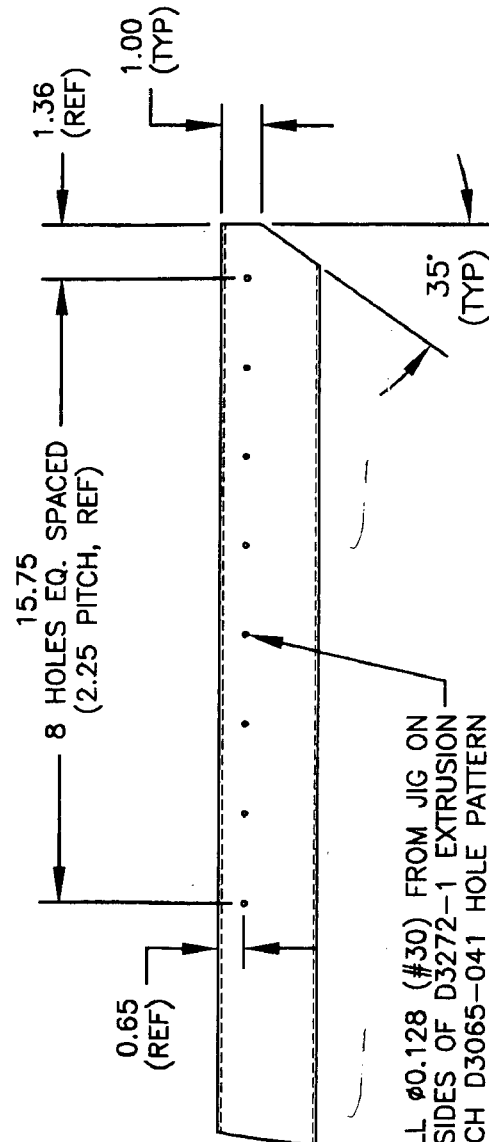


DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)

65396



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C

(SCALE 1:5)

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8					2	2	D2274	RADIUS BLOCK
								D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.